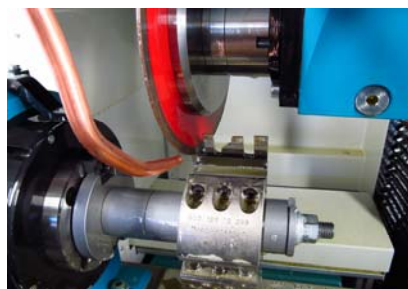



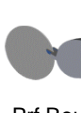







HSS Profile Milling Cutter Ø194 Z2

A16-210

The grinding of deep pocketlike profiles in HSS Profiled Cutters requires a switch of the WGA of the wheel to be able to achieve enough side clearance and when the profiled knives are very long. On a CFG configuration, roughing is done from behind, where the profilepregrinding and finishing is done above or at the point chosen with WGA.



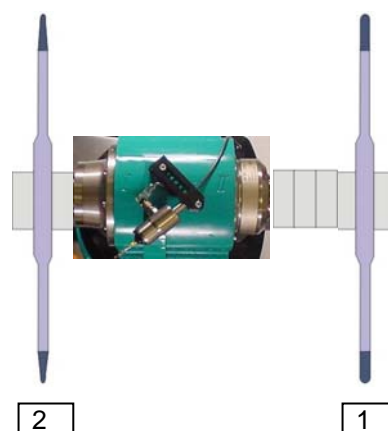
1. Cycletime for Production

Workpiece: Ø 194 mm, Z 2, Length 60 mm, clearance angle 20°, rake angle 13° Material HSS					
Operations					
Feed [mm/Min]	2000	45	65	95	130
Power [kW]		2	1	1	1
Cutting feed [m/s]		32	32	32	32
Used wheels					
Grinding time [s]	6	1600	183	128	96
Total cycle time	33 Min 33				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	14F1 Ø200 R1.5
2	14F1 Ø200 R1.0



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG Coolant: Synthetic Oil, pressure 6 bar
Control: Fanuc 310i Software: Quinto 5
Accessories:

Responsible engineer: OP, 2.5.11

www.schneeberger.ch

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